

Date: Tuesday, 2/26/2008 8:02:43 AM  
 User: Kim Johnston

# Process Sheet

|   |                                       |
|---|---------------------------------------|
| Customer : CU-DAR001 Dart Helicopters Services                                | Drawing Name : BALL JOINT ROD END     |
| Job Number : 37641  |                                       |
| Estimate Number : 12440   |                                       |
| P.O. Number :   | Part Number : D35183                  |
| This Issue : 2/26/2008 S.O. No. :   | Drawing Number : D3518 REV B          |
| Prsht Rev. : NC   | Project Number : N/A                  |
| First Issue : 1 / 1 Type : PURCHASED PARTS                                    | Drawing Revision : B                  |
| Previous Run : 31684  | Material :                            |
| Written By :  | Due Date : 3/10/2008 Qty: 10 Um: Each |
| Checked & Approved By : <u>JD 08 02 26</u>                                    |                                       |
| Comment : Est Rev A New Issue 06-11-22 JLM<br>est rev B rev b dwg 07.04.09 EC |                                       |

## Additional Product

Job Number:



|         |                       |               |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

|     |         |         |
|-----|---------|---------|
| 1.0 | 2458K14 | rod end |
|-----|---------|---------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)  
 rod end

|     |    |            |
|-----|----|------------|
| 2.0 | PG | PURCHASING |
|-----|----|------------|



Comment: Issue P/O: 5796  
 Purchase Part Number: 2458K14  
 Supplier: Mc Master Carr  
 Certificate of conformity is required

C208/02/26

(10)

|     |             |                       |
|-----|-------------|-----------------------|
| 3.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|-----|-------------|-----------------------|



Comment: PACKAGING RESOURCE #1  
 Receive & Inspect For Transit Damage  
 Ensure certificate of conformity is attached

PC 8/3/3

|     |     |                   |
|-----|-----|-------------------|
| 4.0 | QC6 | DIMENSIONAL CHECK |
|-----|-----|-------------------|



Comment: DIMENSIONAL CHECK

08/03/08 (10)

|     |             |                       |
|-----|-------------|-----------------------|
| 5.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|-----|-------------|-----------------------|



Comment: PACKAGING RESOURCE #1  
 Identify and Stock  
 Location: 606

8/3/3 50

(10x)

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes (No) DQA: D Date: 08/03/04  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                                |                                 |                |                           |                       |                          |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action<br>Section B |                                 | Sign &<br>Date | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng           | Action Description<br>Chief Eng |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

Date: Tuesday, 2/26/2008 8:02:43 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BALL JOINT ROD END

Job Number: 37641

Part Number: D35183

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(10)

Comment: FINAL INSPECTION/W/O RELEASE

2008/03/04

Job Completion



2008/3/04 (10)

**Dart Aerospace Ltd**

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

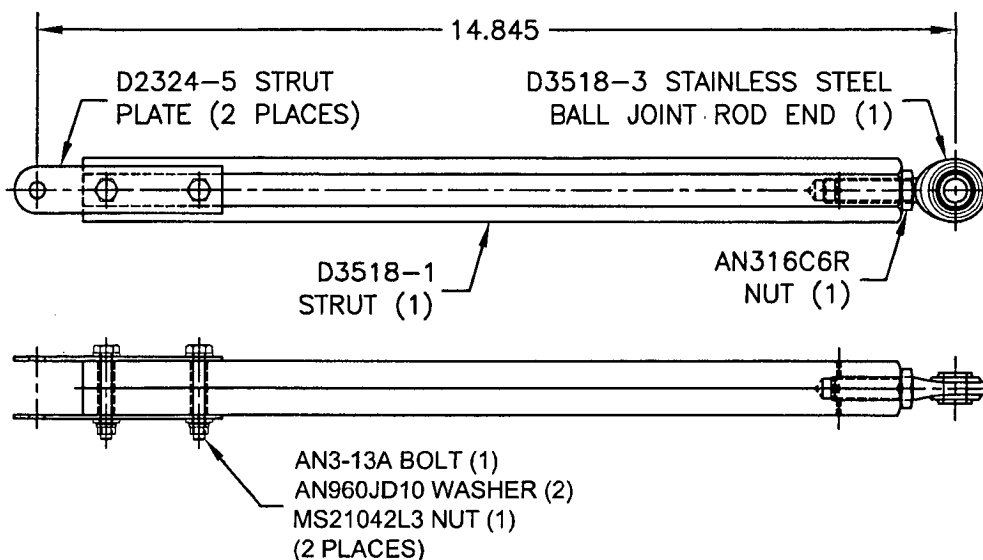
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                                |                                 |                |                           |                       |                          |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action<br>Section B |                                 | Sign &<br>Date | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng           | Action Description<br>Chief Eng |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



|                              |                                |  |                        |
|------------------------------|--------------------------------|--|------------------------|
| DESIGN<br><i>[Signature]</i> | DRAWN BY<br><i>[Signature]</i> | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br><b>PH</b>         | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br>D3518                                     | REV. B<br>SHEET 1 OF 3 |
| DATE<br>06.10.23             |                                | TITLE<br>BASKET (A119) STRUT                             | SCALE<br>1:3           |
| A                            | 06.06.21                       | NEW ISSUE  |                        |
| B                            | 06.10.23                       | RE-DESIGN  |                        |



**D3518-041 STRUT ASSEMBLY**

| QTY<br>-041 | Part Number | Description                        |
|-------------|-------------|------------------------------------|
| X           | D3518-041   | STRUT ASSEMBLY                     |
| 2           | D2324-5     | STRUT PLATE                        |
| 1           | D3518-1     | STRUT                              |
| 1           | D3518-3     | STAINLESS STEEL BALL JOINT ROD END |
| 2           | AN3-13A     | BOLT                               |
| 1           | AN316C6R    | NUT                                |
| 4           | AN960JD10   | WASHER                             |
| 2           | MS21042L3   | NUT                                |

**NOTES:**

- 1) IDENTIFY WITH DART P/N "D3518-041" USING FINE POINT PERMANENT INK MARKER

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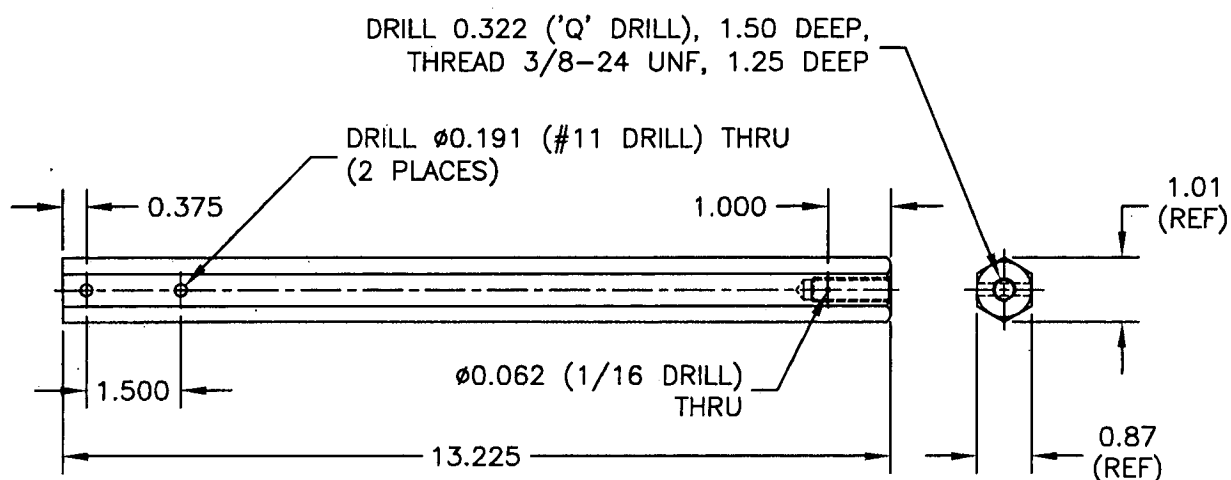
06.11.17 *[Signature]*

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|                      |                      |   |                        |
|----------------------|----------------------|---|------------------------|
| DESIGN<br><i>B</i>   | DRAWN BY<br><i>B</i> | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br><i>PH</i> | APPROVED<br><i>H</i> | DRAWING NO.<br>D3518                              | REV. B<br>SHEET 2 OF 3 |
| DATE<br>06.10.23     |                      | TITLE<br>BASKET (A119) STRUT                      | SCALE<br>1:3           |



### D3518-1 STRUT

#### NOTES:

- 1) MATERIAL: M6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM HEX BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF DART MATERIAL SPEC M6061T6H0.875)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES 0.005 TO 0.010 MAX

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NO. 37641

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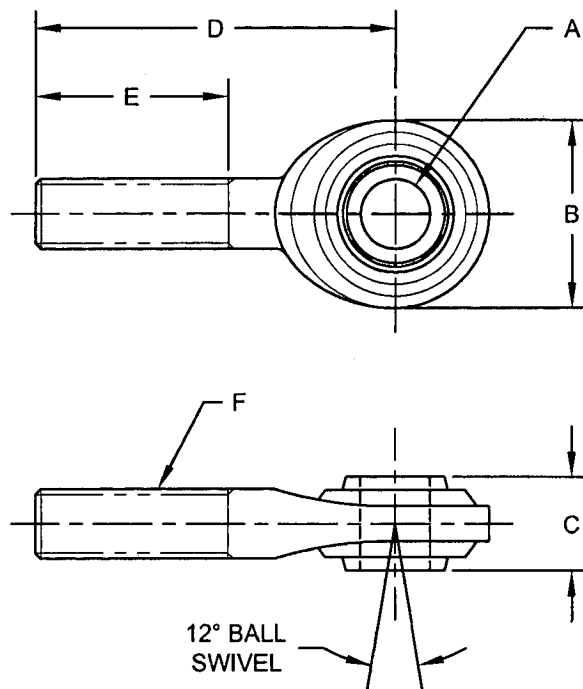
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| CHECKED<br><i>PH</i>         | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br>D3518                              | REV. B<br>SHEET 3 OF 3 |
| DATE<br>06.10.23             |                                | TITLE<br>BASKET (A119) STRUT                      | SCALE<br>1:1           |

## SPECIFICATION CONTROL DRAWING



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NO. *37641*

| DART P/N | A     | B    | C    | D     | E    | F                 | LOAD* | POSSIBLE SUPPLIER             |
|----------|-------|------|------|-------|------|-------------------|-------|-------------------------------|
| D3518-3  | 0.375 | 1.00 | 0.50 | 1.938 | 1.25 | 3/8-24<br>UNF, RH | 4012  | McMASTER-CARR,<br>P/N 2458K14 |

\* Indicated load is Static Radial Load Capacity in lbs

### NOTES:

- 1) TYPE: MALE THREADED SHANK CARBON-FIBER-REINFORCED PLASTIC RACE BALL JOINT ROD END
- 2) MATERIAL: ZINC PLATED STEEL HOUSING BALL WITH PTFE LUBRICATED CARBON-FIBER-REINFORCED PLASTIC RACE.
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

RELEASED

*06.11.17* *[Signature]*

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# McMASTER-CARR®

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Aurora, OH 44202-8087  
330-995-5500  
cle.sales@mcmaster.com

Dart Aerospace Ltd  
1270 Aberdeen St  
Hawkesbury ON K6A 1K7  
Canada

Purchase Order  
PO00005796

Page 1 of 1

McMaster-Carr Number  
6763675-02

02/27/2008

| Line | Description | Ordered | Shipped |
|------|-------------|---------|---------|
|------|-------------|---------|---------|

|   |  |            |    |
|---|--|------------|----|
| 5 | <b>4146A93</b> 1/2" Hex Shank Arbor for 1-5/16" to 2-9/16", Hole Cutter for Sheet Metal                          | 1<br>Each  | 1  |
| 1 | <b>9504K17</b> Brass Shim Stock Roll, .004" Thick, 6" Width X 60" Length   | 3<br>Each  | 3  |
| 2 | <b>2458K14</b> Carbon-Fiber Race Ball Joint Rod End, 3/8"-24 Right-Hand Male Shank, 4012 Pound Load Capacity     | 10<br>Each | 10 |
| 3 | <b>8353T74</b> Pneumatic Wheel with One-Piece Rim, 18" X 5.9", center Hub, 1-1/4" Axle, Roller Bearing, 1590#cap | 12<br>Each | 7  |

3 - 54 - 13 **66 - 25** A93

1 EA

3 - 262

3 - 297

8 - 79

Shipped separately from our Chicago warehouse on 02/27

|   |  |            |   |
|---|--|------------|---|
| 3 | <b>8353T74</b> Pneumatic Wheel with One-Piece Rim, 18" X 5.9", center Hub, 1-1/4" Axle, Roller Bearing, 1590#cap | 12<br>Each | 5 |
| 4 | <b>4146A38</b> Hole Cutter for Sheet Metal, 2-1/4" Diameter, Tin Coated  | 1<br>Each  | 1 |

Dart Aerospace Ltd

Assembly  
Area

88

Cycle

30

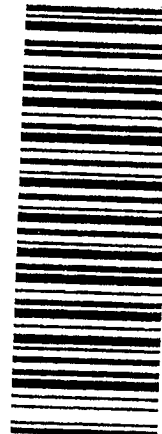
Shelf

801

Documents

4

EXP



110 lbs  
4 lines

FW1BSP38  
02/27/2008  
10:48/11:02  
282



8005839689192